Work Orde June-04-12 8:20		125		*85′	125*							Page 1	
item ID: Revision ID:	D350-591-21	13	 A	Accept	*N90	0040	100)*	Setup :	Start	*N	S1*	
Item Name:	Heli-Access-S	tep, Short LH								Stop	*N	S2*	
Start Date: Required Date: Reference:	04/06/2012 18/06/2012	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Iter Custome			-					
Approvals:	Process Pla QC:	n:MLT	Date: 12/06/04	Tooling: SPC (Y/N):		Date:				Start Stop	*N	R1* R2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool II	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp	-
Draw Nbr	Rev	ision Nbr		-	. — —		···-						
D3078 DSI 9472	A A												
100				0.00					1				
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110				0.00									
110 Large Fab		Large Fab Memo		0.00				5	9	5		Ae_	

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.

Memo

3-Deburr

Large Fab

Dart Aerospace	Ltd
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W/O:			1	WORK (ORDER CHA	NGES			· · · · · · · · · · · · · · · · · · ·		
DATE	STEP	PRO	OCEDURE C	HANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:									
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NCR:		•	WORK OR	DER N	ON-CONFOR	RMANCI	E (NCF	1)			
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descr		Action Descripti	cription Sign &			cation	Approval Chief Eng	Approval QC Inspector
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Work Ord <i>June-04-12 8:2</i>		125			125*			,			Page 2
Item ID: Revision ID: Item Name:	D350-591-2 Heli-Access-S			Accept	*N900	0401	NN*	Setup	Start Stop	ı VI .	S1* S2*
Start Date: 04/06/2012 Required Date: 18/06/2012 Reference:		Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item ID: Customer:						
Approvals:	Process Pla	in:	Date:	Tooling:		ate:	_	Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:	-		Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # P	lan Acco	ept Re Qt		Reject Number	Insp. Stamp
120		QC6- Inspect dimension	s to drawing	0.00	1						· ~
120 QC Quality Control		Memo		0.00	Hos		5		7		12.07.03
130				0.00							
130		Large Fab					5	, 	S		NE
Large Fab		Memo		0.00					9-		12.01.0
Large Fab		2-Weld Supp D3072	num Rod <i>1208</i> 54	Y veld Fwd End Plate as per	QSI 004 & Dwg						12.07.04 Ae 12.07.04
140		QC9- Inspect visual per 0	QSI004- Fusion Welds	0.00			_	7			
*14 0 *		Memo		0.00			5	4	9_		BEROFI

Quality Control

Dart Aerospace L	.td
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W/O:			V	ORK ORDER CHANGE	S			-	
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	_ Fault Ca	tegory:	NCR: Yes	s No DQ	A:	Date:	
	R	esolution:	Disposition: QA			Closed:		Date: _	
NCR:	ICR:			DER NON-CONFORMA	NCE (NC	R)		-	
DATE	STEP	Description of NC	In it in I	Corrective Action Section		Sign & Verification App			Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Dat		ion C	Chief Eng	QC Inspector
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Work Order ID 85125 Page 3 June-04-12 8:20:50 AM Item ID: D350-591-213 Accept *N900040100* Setup Start **Revision ID:** Item Name: Heli-Access-Step. Short LH 04/06/2012 **Start Qty:** 5.00 **Start Date:** Cust Item ID: **Required Date:** 18/06/2012 **Req'd Qty:** 5.00 **Customer:** Reference: Run Process Plan: Approvals: Date: _____ Tooling: Date: _____ SPC (Y/N): Date: Sequence ID/ **Operation** Tool # Plan Set Up/ Tool ID Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 150 QC5- Inspect part completeness to step on W/O *150* Salorla Memo W Quality Control 160 Chemical Conversion Coat per QSI005 4.1 0.00 *160* HandFinish Memo 0.00 Hand Finishing 170 QC3- Inspect Part Finish 0.00 5 f /K *170*

0.00

Memo

Quality Control

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W/O:			V	ORK ORDER CHANGE	S						
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	·	PAR #:	_ Fault Ca	NCR: Yes	NCR: Yes No DQA: Date:						
	R	esolution:	Disposition: QA				Date: _				
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NCR)					
DATE	STEP	Description of NC	1 141 - 4	Corrective Action Section	n B Sign &	Verification	Approval	Approval			
		Section A	Initial Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector			
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Quality Control

Dart Aerospace	Ltd
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W/O:			ES						
DATE	STÉP	PRO	CEDURE CI	HANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	ategory:	_ NCR: Ye	s No D	QA:	Date: _	
	R	esolution:	Disposit	Disposition:Q				Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	ANCE (NO	CR)			
DATE	STEP	Description of NC		on B	Veri	ification	Approval	Approval	
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig: Da	n.&.∣ _{Se}	ection C	Chief Eng	QC Inspector
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Work Orde June-04-12 8:2		125		*851	125*		Page 5
Hem ID: Revision ID: Item Name:	D350-591-2 Heli-Access-S		. Terre Luce	Accept	*N900040100	* Setup Start Stop	*NS1*
	04/06/2012	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item ID: Customer:	·	*NS2*
Approvals:		an:		Tooling: SPC (Y/N):	Date: Date:	Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 230 *230* HandFinish Hand Finishing)	Operation Description Chemical Conversion C Memo	oat per QSI005 4.1	Set Up/ Run Hours 0.00			Reject Insp. Number Stamp
*240 *240 *Powdercoat Powder Coating	41	FINISH TIN	12',10 ME: 12',10 MPERATURE: 36 ME: 12',40	0.00	LH	XXX H	M.L W. 1/1
250 *250* HandFinish		Wing Walk as per dwg (2SI005 4.4 Batch 1915	0.00		5/4.	B/12716

Hand Finishing

W/O:			WORK ORDER CHANGES										
DATE	STEP	PROG	CEDURE CH		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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Part No	:	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQA:	Date:						
	R	esolution:	ion:	QA: N/C Clo	sed:	Date: _							
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NCR)							
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector					
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Work Orde June-04-12 8:20	er ID 85125 0:50 AM	174 - 2 4	*85	5125*		÷ ,				Page 6
Revision ID:	D350-591-213 Heli-Access-Step, Short LI	-	Accept	*N900	0040	1100)*	Setup Star Stop	1 1	S1* S2*
Start Date: Required Date: Reference:	04/06/2012 Start Qty 18/06/2012 Req'd Qt		*5* *5*		Cust Item ID: Customer:					
Approvals:	Process Plan:	Date:	Tooling:		Date:	.=]	Run Star	1/1	R1*
	QC:	Date:	SPC (Y/N):		Pate:			Stop	` *N	R2*
Sequence ID/ Work Center ID 60 *260* QC QC QUality Control	QC3- Inspec	n	Set Up/ Run Hours 0.00	Tool ID	Tool #	Code	Accept Qty 5 h t (Qty	Reject Number	Insp. Stamp
70 *270* Packaging ackaging	Pick Kit	Memo	0.00				_5_	- 		13/07/17
⁸⁰ *2ጸበ* ^{2C}		nspect kits for completenes	ss 0.00	s) dala			<u>~</u> 5			
QC Quality Control 70 *270* Packaging ackaging	Pick Kit ! QC4- 100% I	Memo Inspect kits for completenes	0.00 0.00 ss 0.00	s Jalaha				`		

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W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr Approval QC Inspector			
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date:			
Resolution:			_ Disposit	ion:	QA: N/C	losed:					
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NC	R)					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign Date	& Sect	cation ion C	Approvai Chief Eng	Approval QC Inspector		
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Work Order ID 85125 <i>June-04-12 8:20:50 AM</i>			*851	Page 7		
Item ID: Revision ID:	D350-591-213		Accept	*N900040100*	Setup	Start *NS1*
	Heli-Access-Step, Short LH 04/06/2012 Start Qty: 18/06/2012 Req'd Qty:	. ,		Cust Item ID: Customer:		Stop *NS2*
Approvals:	Process Plan:	Date:	Tooling: SPC (Y/N):	Date:	Run	Start *NR1* Stop *NR2*
Sequence ID/ Work Center II 290 *290*	Operation Description Packaging		Set Up/ Run Hours 0.00	Code Qt		ject Reject Insp.
Packaging Packaging	Loca	tify and pack for shipping as position: Rev:	0.00 er PPP D350-591-213	<u></u>		(c/s/s//)(S
300	QC21- Final Insp	pection - Work Order Release	0.00			1- 1- 1- 10 - 10
3UU	Men	10	0.00			12/4/18

Quality Control

MF 12-07-18

Dart Aerospace	Ltd
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes I	No DQ	A :	Date: _				
Resolution: Disposition:												
NCR:		V	VORK OR	DER NON-CONFORM	ANCE (NCR)						
DATE	STEP	Description of NC			tion B	Verification Approval			Approval			
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	ion C	Chief Eng	QC Inspector			
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Picklist Print

June-04-12 8:20:55 AM

Work Order ID: 85125

Parent Item:

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

85125

D350-591-213

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:B05.10.14Modified step 10KJ/EC

IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D

10.03.17 incorporate seq 180 to 200 remove qc5 DD verified

by:JLM

IPP Rev:E

10.11.15 update qty on AN4-11A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			110	Each	156.6100	0.5	2.5			
D2622-12 Step Extrusion	UC					•			**	A	2 12	.06-	26

Location	Loc Qty	Loc Code	
HALL	16.37		
46910	2		
64409	6		
66970	7.7		
68293	0.25		
72131	0.42		
WA	130.88		
81507	4.88		
83894	126		2.5
WA013	9.36		
75781	2		
77612	7.36		
			.,,,,,

W/O:		,	W	ORK ORDER CHANGE	S				·
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	Date:	
Resolution:			Dispositi	on:	QA: N/C Cle	osed:		Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:		V	WORK ORE	DER NON-CONFORMA	NCE (NCR)			
		Description of NC		Corrective Action Section B Verifi			cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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Work Order ID: 85125

Parent Item:

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

85125 *D350-591-213*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

D3067-1

End Plate

D3067-1

Manufactured

130

172.0000

<u>Location</u>	Lo	oc Qtv	Loc Code		
WA		139			
78608		4			
83855		60			5
84534		75			
WA016		33			
67582		2			
68214		1			
79607		1			-
83053		29			
	130	Each	53.0000	1	5

Each

D3063-1

Manufactured

1,2.07.03

Support

<u>Location</u>	<u>Lo</u>	c Qty	Loc Code	
WA016		53		
71886		53		
	180	Each	3,464.000	16

MS20600-AD4W4

Purchased

No

**

Az 12.07.12

MS20600-AD4W4

Rivets

Location	Loc Oty	Loc Code
321	1000	
121652	1000	
ST321	2324	
121011	9	
121340	315	
121444	2000	
WA018	140	
118840	140	

80

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROC	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
									·			
Part No	·	PAR #:	_ Fault Ca	tegory:	_ NCR: Yes	No D	QA:	Date: _				
Resolution: Di			_ Disposit	ion:	_ QA: N/C	Closed: _		Date: _				
NCR:	·-	W	ORK OR	DER NON-CONFORMA	ANCE (NC	R)						
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng	ion B Sign	& Se	ification ection C	Approval Chief Eng	Approval QC Inspector			
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Work Order ID: 85125

Parent Item:

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

85125 *D350-591-213*

83854

Location

ST176

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

D3066-1

Manufactured No 180

Each

71.0000

Loc Code

2 10

**

Ac 12.07.12

D3066-1

Spacer

D3065-041

Manufactured

180

71 Each

71

Loc Qty

13.0000

Loc Code

**

Step Leg Assembly Hi

Manufactured No Location Loc Qty WA 13 66149 0 79336 1 80880 12 200

Each

172.0000

**

End Plate

D3067-1

Location	Loc Qty	Loc Code
WA	139	
78608	4	
83855	60	
84534	75	
WA016	33	
67582	2	
68214	1	
79607	1	
83053	29	

W/O:			N	ORK ORDER CH	ANGES					-	
DATE	STÉP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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*		PAR #:	Fault Ca	tegory:	N	CR: Yes	No DQA	lo DQA: Date:			
	R	esolution:	Disposit	ion:	Q	A: N/C CI	N/C Closed: Date:				
NCR:		,	WORK OR	DER NON-CONFO	RMANC	E (NCR	1)			· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	Description of NC	otion of NC		Section B		Verification		Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Descrip	otion	Sign & Date	Section C		Chief Eng	QC Inspector	
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June-04-12 8:20:55 AM

Work Order ID: 85125

Parent Item:

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

85125 *D350-591-213*

Location

ST353

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

116.0000 **

AN3-35A

D2856-400

Manufactured

Purchased

No

No

No

121652

270

270

Loc Qty

116

116

Each

230.5445

Loc Code

Loc Code

81875

**

Abrasion Strip





AN4-11A

Purchased

Location Loc Qty ST403 216 81875 216 ST409 14.5445 63735 0.6696 68076 0.3149 71164 8.46 79551 5.1

270

Each

296.0000

Location Loc Qty Loc Code ST356 296 118706 46 120731 100 121243 50 121708 121708 100

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W/O:			V	ORK ORDER CHANGE	S					
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:		PAR #:	_ Fault Category: NCR: Yes No DQA: _				A:	Date:		
Resolution:			_ Disposit	ion:	QA: N/C CI	osed:		Date: _	· ·	
NCR:		W	ORK OR	DER NON-CONFORMAN	ICE (NCF	R)				
DATE	STEP	Description of NC	Corrective Action Section B			Sign & Verification Section C		Approval	Approval	
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Picklist Print

June-04-12 8:20:55 AM

Work Order ID: 85125

Parent Item:

D350-591-213

AN960JD416

Parent Item Name: Heli-Access-Step, Short LH

85125

D350-591-213

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0463J Purchased

No

270

Each 30.0000

Loc Code

121912

Page 5

Manufactured No

Location Loc Qty ST351 10 116289 119097 20 270 Each

20.0000

84135 JB

MS21042L3

Purchased

No

83273

Location

ST480

20 20 270 Each

Loc Qty

2,195.000

Loc Code

Location	Loc Qty	Loc Code	*	
ST300	2195			
117885	32			
119017	952			
119075	138			
121349	221	•		
121444	852		1	121444

June-04-12 8:20:55 AM

Shop Packet Print

Page 5

W/O:			W	ORK ORDER CH	ANGES					
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Part No	:	PAR #:	_ Fault Cat	egory:	NC	R: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Dispositi	on:	QA	N/C Cld	sed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Act					ation	Approval	Approval
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June-04-12 8:20:55 AM

Work Order ID: 85125

Parent Item:

D2732

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Purchased

Manufactured

Manufactured

85125

D350-591-213

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Oty: 5:00

Required Qty: 5.00

1,261,000

**

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AN4-13A

No

No

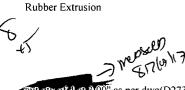
Location Loc Qty ST357 1261 119449 33 120187 19 120422 2 120770 207 121652 1000 270

270

Loc Code 520.9153

Each

5.263158



as per dwg(D2732-030)

No

No

Location Loc Qty ST410 520.915299 70987 20.915299 83560 500

90.0000

Each

Loc Code



83560

Loc Qty Location Loc Code ST480 90

270

90 83261 270 0.0000 Each

NAS1149D0363J Purchased

W/O:			V	ORK ORDER CHANG	ES			*	
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No) :	PAR #:	Fault Ca	tegory:	_ NCR: Ye	s No DO	QA:	Date: _	
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NCR:			WORK OR	DER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC Corrective Action			tion B	Verif	ication	Approval	Approval
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Work Order ID: 85125

Parent Item:

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

85125 *D350-591-213*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

Purchased

No

No-

270

Each

3,910.000

Loc Code

121444

Loc Qty Location ST300 3910 119075 116 121011 537 2957 121444 121652 300 270 Each

169.0000

137122416 20

Location Loc Code Loc Oty ST358 169 120498 14 30 121060 121444 75 121541 50

W/O:			W	VORK ORDER CHANGI	ES				
DATE	STÉP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						,			*
					ì				-
Part No:		PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA	۱:	Date:	
Resolution: Disposition:				ion:	QA: N/C C	osed:	·	Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC	Description of NC Corrective Action Section			1 VARITICATION			Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Approval Chief Eng	QC Inspector
•	4								
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DESIGN	DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	6
CHECK	E D	APPROYED	DRAWING NO. R	REV. A
- AP		- स	D3076 SHEET	1 OF 2
02.09.11			STEP ASSEMBLY, HI SHORT	SCALE NTS
Α	0:	2.09.11	NEW ISSUE	



Part No.	Description	QTY	QTY	
		-041	-042	
D3078-041	Step Assembly, High Short (LH)	Х		
D3078-042	Step Assembly, High Short (RH)		Х	
D2622-60	STEP EXTRUSION	1 .	1	
D3063-1	SUPPORT	1	1	
D3065-041	LEG ASSEMBLY	1	1	
D3066-1	SPACER	2	2	
D3067-1	END PLATE	2	2	
MS20600AD4W4	RIVET	16	16	

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WITHOUT NOTICE
WORK ORDER

90/21
SOJ21
SOJ21







DESIGN APPROVED

DRAWING NO.

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA

REV. A

SHEET 2 OF 2

HI SHORT

STEP ASSEMBLY,

02.09.11







1.00



DETAIL A (1:5)

1.36

35.1° (TYP)

LENGTH W/O ENDCAP

0.65

59.75 (WITHOUT ENDPLATES)

TO AFT FACE OF D3063-1)

54.56 (DIST, FROM 1ST HOLE

SURFACE TO BOTTOM OF TOP RADIUS

MS20600AD4W4 RIVET (16 PLACES)

D3063-1 SUPPORT D2622-60 STEP EXTRUSION APPLY BLACK ANTI-SKID ON TOP

D3066-1 SPACER

(2 PLACES)

D3065-041

LEG ASSEMBLY

DETAIL B

GRIND FLUSH

DETAIL B (1:5)

D3063-1 SUPPORT

(REF) D3067-1 END PLATE

DRILL ϕ 0.128 (#30) ON BOTH SIDES OF D2622 EXTRUSION TO MATCH D3065-041 HOLE PATTERN. RIVET D3065-041 TO D2622 USING

(2 PLACES)

ĦS.

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER AND

INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6 REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
Х		1		D350-591-213	Heli-Access-Step ™, Short Step - High Skid, LH
	X			D350-591-214	Heli-Access-Step ™, Short Step - High Skid, RH
		Х		D350-591-215	Heli-Access-Step ™, Short Step - Low Skid, LH
			Х	D350-591-216	Heli-Access-Step ™, Short Step - Low Skid, RH
4	4	4	4	AN4-16A	BOLT



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

BY: D. SHEPHERD (DE # 02)

DATE: 09.08.05 CERT. NO.: SH92-6 ISSUE NO.: 11

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Α	NEW IS	SSUE		RF	09.08.05				
REV.	DESCRIPTION		BY	DATE					
DESIGN	DESIGN Q		DART AERO	DART AEROSPACE LTD					
DRAWN		RF	HAWKESBURY, ON						
CHECKE	ΞD	u	DRAWING NO.		REV. A				
MFG. AF	PR.	ROW	DSI 9472		SHEET 1 OF 2				
APPRO\	√ED	/W	TITLE		SCALE				
DE APPI	R.	_#-	BOLT ADDITION		NTS				
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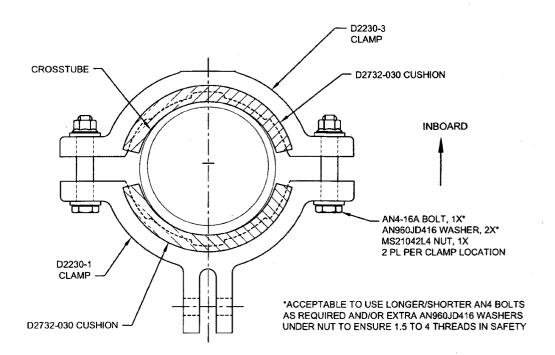


FIGURE 1: CLAMP DETAIL OPTIONAL CLAMP CONFIGURATION

CANADA
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AIRCRAFT CERTIFICATION
BRANCH
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D. SHEPHERD (DE # 02)

DATE: 09.08.05

CERT. NO.: SH92-6

ISSUE NO.: 11

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA				
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MFG. APPR.	NA	DSI 9472	SHEET 2 OF 2			
APPROVED	W	TITLE	SCALE			
DE APPR.	-#-	BOLT ADDITION	NTS			
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25.05

DART AEROSPACE LTD.

Qty	Qty	y •Qty	Qty	Qty	Qty	Qty	Qty	Part Number	Description	
-211	-212	213	-214	-215	-216	-311	-312			
Х								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH	
	Х							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH	
		Х						D350-591-213	Heli-Access-Step™, Short Step - High Skid, LH	
			Х					D350-591-214	Heli-Access-Step™, Short Step - High Skid, RH	
				Х				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH	
—					Х			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH	
		· · · ·				Х		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH	
							Х	D350-591-312	Heli-Access-Step™, Long Step - High Skid, RH	
-								100000	Tion Floods Otep , Long Ctop A light Onld, 141	
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)	
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)	
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)	
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)	
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)	
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)	
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)	
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)	
4	4							-D2182B035	RUBBER CUSHION	
		12	2	2	_2			D2230-1	MOUNTING LUG	
		12 -	2	2	2	4	4	D2230-3	MOUNTING LUG	
8	8							D2274	RADIUS BLOCK	
						2	2	D2618	BUSHING	
4	4	/ 4	4	4	4	·		D2732-030	[∤] CUSHION	
2	2	/ 1	1	1	1	2	2	D2856-400-720	ABRASION STRIP	
2	2							D3064-1	CLAMP	
1	1							D3079-041	SUPPORT ASSEMBLY	
4	4							D3080-1	CLAMP	
						2	2	D3235-1	MOUNTING LUG	
						1	1	D3278-041	SUPPORT ASSEMBLY	
						2		ANI2 25A	BOLT	
2	2	2	2	2	2		2	AN3-35A	BOLT	
10	10	2	2	2	2			AN4-11A7		
		7 4	4	_4	4	8	8	AN4-13A	BOLT	
<u></u>		 _ _ 				2	2	AN5-36A	BOLT	
4	4	/ 4	4	4	4	14	4	AN960JD10 💉	WASHER	
20	20	/12	12	12	12	16	16	AN960JD416	WASHER	
						4	4	AN960JD516	WASHER	
2	2	2	2	2	2	2	2	MS21042L3	NUT	
10	10	/ 6	6	6	6	8	8	MS21042L4 /	NUT	
		<u> </u>		ļ		2	2	MS21042L5	NUT	
	l	I		I	I	1	1	*DSI 9410-011	STEP MODIFICATION KIT	

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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	Х			D350-591-214	Heli-Access-Step ™, Short Step – High Skid, RH
		Х		D350-591-215	Heli-Access-Step ™, Short Step – Low Skid, LH
			Х	D350-591-216	Heli-Access-Step ™, Short Step - Low Skid, RH
	Peti avadik or A	5.7. 3.7	VI.465	The Agent of the Control	7
4.4.2	14 4 4 4 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	44	4	-AN4-16A/	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

BY: D. SHEPHERD (DE # 02)

DATE: 09.08.05 CERT. NO.: SH92-6 ISSUE NO.: 11

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